Work Order February-12-14 8	r ID 113120 B:35:53 AM	35-25	*113	3120*						Page 1
Revision ID:		13120	Accept	*N90	0040	100	N *	Setup Star	171	S1*
	Vearplate Center /10/14			Cust Iter					^ \]	S2*
Reference:		16)				_]	Run Star	t war	
	Process Plan: MLT QC:	Date: <u> </u>	ZTooling: SPC (Y/N):		Date: Date:			Stop	, ^I \	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool II	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									 .
D3535	Rev B									
*1 \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	FLOW WATER JET Memo 1-Cut as pe Deburr if n		0.00 0.00 Prog Rev:	5_ 2-			16	O		Ae 14-02-0
110 *110* QC Quality Control	QC2- Inspect parts off i	machine FAI/FAIB	0.00				16_	_ 0		de 14-02-0
120 *1 20* oc	QC8- Inspect parts - sec	cond check	0.00 27	124			16			

Quality Control

DQA:		. Date:											`	
					WORK ORDER NON-	-CC	ONFO	RMANCE / UP				_		AEROSPACE
QA Closed:		Date:								Wo	ork Order up	date only		
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							:
					Rework			Skid-tube	Crosstube			Water Jet	\neg	Engineering
Part N	0.				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	\exists	Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	0			_	Suspected Unapproved			Large Fab	Composite [Supplier]	
Root				Desci	ription of work order update	1	nitial	Acti	on		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification		QC Inspector
Design														
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onapproved		l	ļ			FΔI	III T CA	L TEGORY					_1_	•
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[Bending				Bend	Г]Folio/F	Program	Γ		Outside Dim	ensions [Пр	Pressure/Forced
	Centre No	ot Conce	ntric		BOM/Route		Grain		.		Over/Under	-	_	Set-up
Ì	Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorred	-	_	emperature/Cure
ľ	Crimp/Kii	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	\neg _v	Veld
	Cuffs				Contamination		Instruct	tions Incomplete/U	nclear		Part Moved		v	Wrong Stock Pulled
	Crushing				Countersink		Misali	gned/off center			Positioned V	Vrong _		
	Heat Trea	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge	c	Other
	Inspectio	n Strip in	Tube		Drawing		Misrea	d	_					
	Marks/Ch	natter			Drill Holes		Off-set	•						
ļ	Turning S				Finish		-	Calibration						
	Wave/Tw	ist in Tul	be		Fit/Function		Out of	Sequence						

Work	Orde	er ID	113	120
4 4 O I IV	VIU		110	140

113120

Page 2

February-12-14 8:35:53 AM **Item ID:** Accept D3535-25 *N900040100* Setup Start **Revision ID:** Stop Item Name: Wearplate Center **Start Otv:** 16.00 *16* Start Date: 2/10/14 **Cust Item ID:** Required Date: 2/10/14 Rea'd Otv: 16.00 *16* **Customer:** Reference: Run Start Process Plan: **Approvals:** Date: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID **Description** Code Oty Number Stamp Run Hours Otv 130 0.00 DAS NC BRAKE *130* 30 9-89 Brake NC 0.00 Memo Brake NC 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT83262-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25 DAS 140 OC5- Inspect part completeness to step on W/O *140* OC Memo Quality Control

150

150 Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

16 & H-2-24

DQA:		_ Date:						_				TRANGE
QA Closed:		Data			WORK ORDER NON-	-CC	ONFO	RMANCE / U			adaka auto 🗀	AEROSPACE
QA Closed.		Date:							V	Vork Order up	date only	
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
					Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			-		Use-as-is		Thern	noforming	Finishing		re/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite		Supplier	
Root		7		Desc	ription of work order update		Initial	Act	ion	Sign &		T
Cause	Date	Step	Qty	<i>D</i> C 3 C .	or non-conformance		nief Eng	l .	iption	Date	Verification	QC Inspector
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Supplier												
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Landir	ng Gear			_	General		,					_
	Bending			<u> </u>	Bend		4	'rogram	_	Outside Dim	<u> </u>	Pressure/Forced
	_	Not Conce	ntric		BOM/Route		Grain		_	Over/Under	<u> </u>	Set-up
	Cracks		4	 	Broken/Damage/Defect	_	Hardwa		_	Part Incorred	<u> </u>	Temperature/Cure
	_	ink/Ripple	e/Wave		Burrs		1 '	ion Incomplete/Un	· -	Part Lost/Mi	ssing	Weld
	Cuffs	_			Contamination	lacksquare	4	ions Incomplete/U	Inclear	Part Moved	L	Wrong Stock Pulled
	Crushin			-	Countersink		•	ned/off center	<u> </u>	Positioned V		ا ۔
	Heat Tre		Tubo		Cut Too Short	——	Mislabe		L	Power Loss/	surge	Other
	Marks/0	on Strip in Shattor	rube	-	Drawing Drill Holes	<u> </u>	Misread					
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Work	Order	ID	113120
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vv of K. Of u February-12-14				*11:	3120*					Page 3	
Item ID: Revision ID: Item Name:	D3535-25 Wearplate Ce	enter		Accept	*N90004	೧1 00) *	Setup Star Stop	171	S1* S2*	=
Start Date: Required Date Reference:	2/10/14 : 2/10/14	Start Qty: 16.00 Req'd Qty: 16.00	*16 *16		Cust Item ID: Customer:					. •	
Approvals:		an:	Date:	Tooling: SPC (Y/N):	Date:		F	Run Star Stoj	, "IVI	R1* R2*	
Sequence ID/ Work Center I 160 *160 COC Quality Control 170 170 Packaging Packaging	D	Operation Description QC3- Inspect Part Finish Memo Identify as per dwg & Stoo	ck Location:	Set Up/ Run Hours 0.00 /27 9-5 0.00 /4/2		Code		/		Insp. Stamp	
180 *1 RN* QC Quality Control		QC21- Final Inspection - V	Work Order Release	0.00			MUS	<u> </u>	02-71 M	P NF 14-2-25	5

DQA:		Date:			WORK ORDER NON		201501						DART
QA Closed:		Date			WORK ORDER NON	-C(ONFO	RMANCE / U		\Mor	k Order ur	odate only	AEROSPACE
a, r diosca.		Date.										1	
Work Orde	er:				DISPOSITION				AGAINST	DEP/	ARTMENT	/PROCESS	
					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	noforming	Finishing		Rec/Stor	re/Packaging	Other
NCR N	lo				Suspected Unapproved	spected Unapproved Large Fab Composite						Supplier	_
Root				Desci	ription of work order update		Initial	Act	tion		Sign &		
Cause	Date	e Step	Qty		or non-conformance	Ch	nief Eng	Desci	ription		Date	Verification	QC Inspector
Design													
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Transport													
Unapproved								ļ					
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Landir	ng Gear				General		_						
	Bendii	ng.			Bend		Folio/F	rogram		c	utside Dim	ensions	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain			c	ver/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		P	art Incorrec	ાં _	Temperature/Cure
	Crimp	/Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	P	art Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/l	Jnclear	P	art Moved		Wrong Stock Pulled
	Crushi	-			Countersink		Misalig	ned/off center		P	ositioned V		
ļ	Heat T				Cut Too Short		Mislabe	eled		P	ower Loss/	Surge	Other
	Inspec	tion Strip ir	Tube		Drawing		Misread	t ·	·				
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		g Sequence			Finish		Out of 0	Calibration		_			
	Wave,	Twist in Tu	be		Fit/Function		Out of S	Sequence					-

February-12-14 8:35:56 AM

Work Order ID: 113120

113120

Parent Item:

D3535-25

D3535-25

Parent Item Name: Wearplate Center

Start Date: 2/10/14

Required Date: 2/10/14

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	134.1019	0.51	8.589474	-		
M304S20	GA								**			te 14.	02-23

304/316 .040 Sheet

Location Loc Qty Loc Code MAT020 134.1018948 m126852 0.91 m127454 133.191895

127454 -> 8.6

DQA:		_ Date:		·				_				TRACT
					WORK ORDER NON-	-CC	ONFO	RMANCE / UF				AEROSPACE
QA Closed:		Date:							V	Vork Order เ	ipdate only	
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS	
	• •				Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pr	od. Eng. Coor.	Quality
	<u> </u>				Use-as-is		Therr	noforming	Finishing		ore/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite		Supplier	
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Root				Desci	ription of work order update	l	nitial	Acti		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design	_											
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Handling/Pre												
Material	_											
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Process	\dashv											
Supplier Training												
Transport	\dashv											
Unapproved	\dashv											
onapproved			<u> </u>	l		FAI	ULT CA	TEGORY	*	1		
Landii	ng Gear				General							
	Bending				Bend		Folio/F	rogram	. [Outside Di	mensions	Pressure/Forced
	Centre N	lot Conce	ntric		BOM/Route		Grain	· ·			ritolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorr	eci	Temperature/Cure
	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/N	1issing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	Inclear	Part Move	. [Wrong Stock Pulled
	Crushing	5			Countersink		Misalig	ned/off center		Positioned	Wrong	_
	Heat Tre	at			Cut Too Short		Mislabe	eled		Power Loss	/Surge	Other
	Inspection	on Strip in	Tube		Drawing		Misrea	t	_			
	Marks/C				Drill Holes	L	Off-set					
		Sequence		L	Finish		Out of	Calibration				
	Wave/Tv	wist in Tul	be		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order: 1/3/70	
Description: Wearshoe	Part Number: D3535-25	
Inspection Dwg: D3535 Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

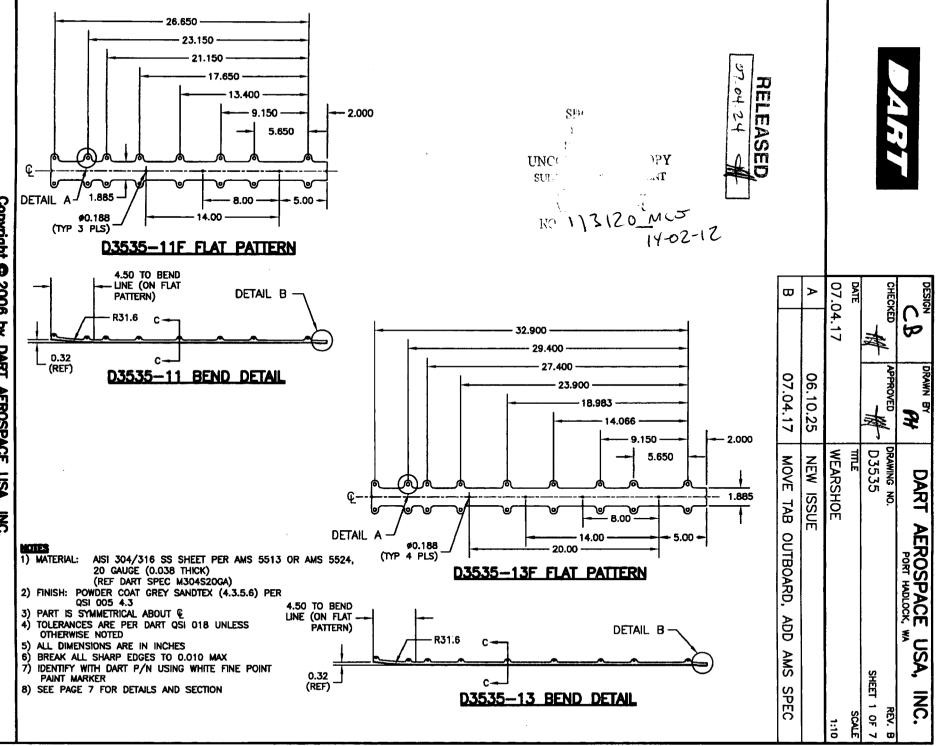
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1,885	_		Y	JKM-05
1.937	+/-0.010	1,937	Attitus .		· ·	
1.450	+/-0.010	1,450	_		V	
5.450	+/-0.010	5.450	_		V	
10.900	+/-0.010	10.900	_		7	
16.350	+/-0.010	16.350	_		τ	
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Measured by: Ac Audited by: 27 Prototype Approval: N/A

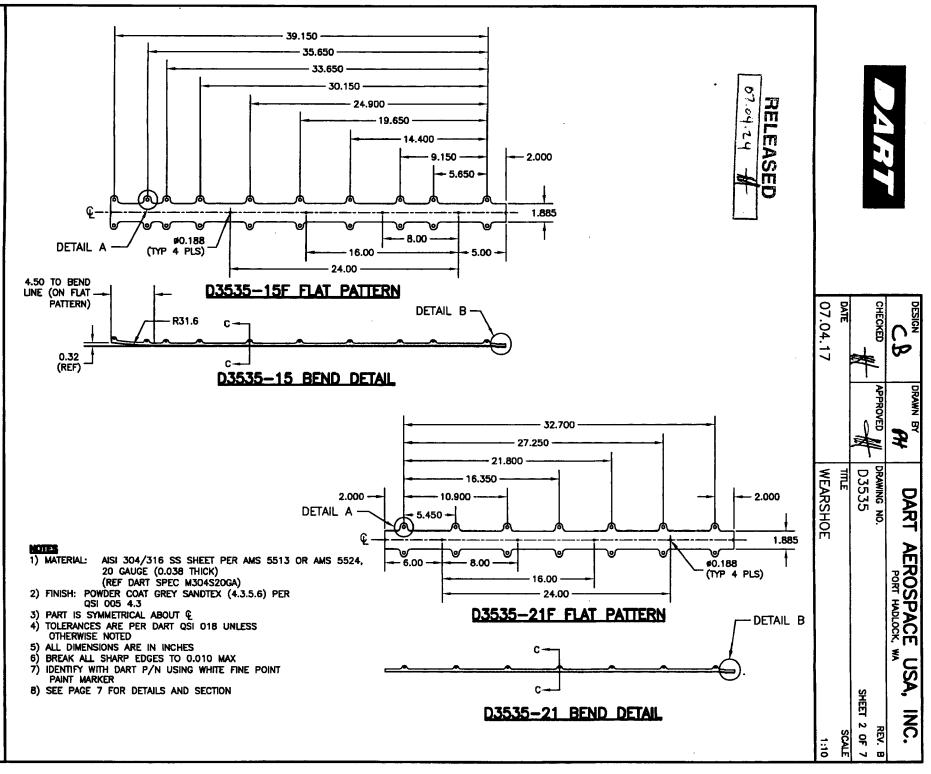
Date: 14-02-23 Date: 142 24 Date: N/A

Rev	Date	Change	Revised by Approved
Α	07.11.23	New Issue	KJ/EC/DD
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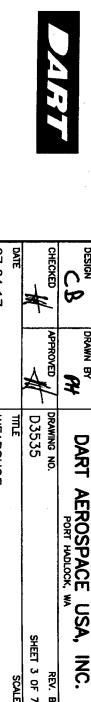
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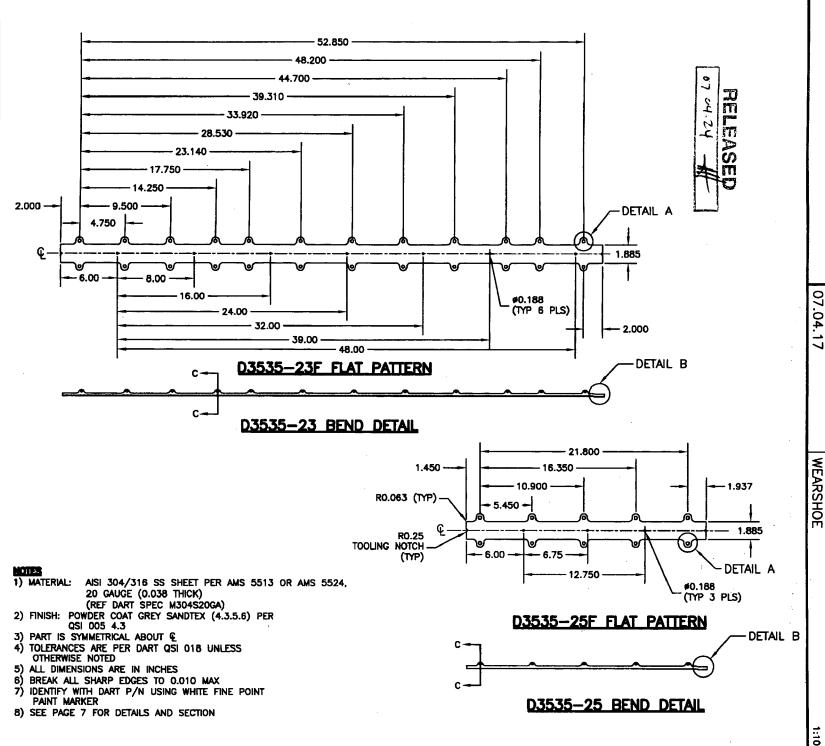
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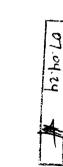
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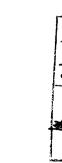
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PELEASE





D3535-31F FLAT PATTERN

22.500 - 19.000

DETAIL A

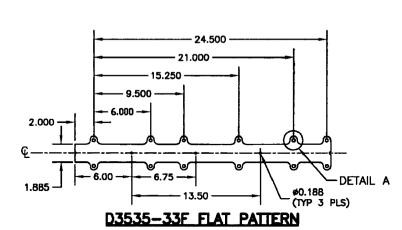
ø0.188 (TYP 3 PLS)

9.500

6.000

2.000

1.885



D3535-33 BEND DETAIL

AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)

(REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION



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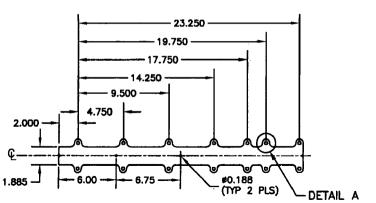
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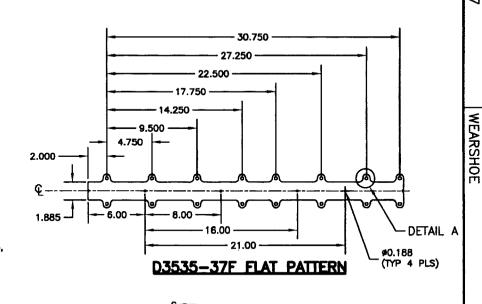


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D3535-35F FLAT PATTERN

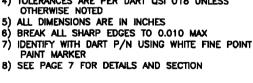




D3535-37 BEND DETAIL

- AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) 1) MATERIAL:
- (REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
- QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- PAINT MARKER



PURPOSE

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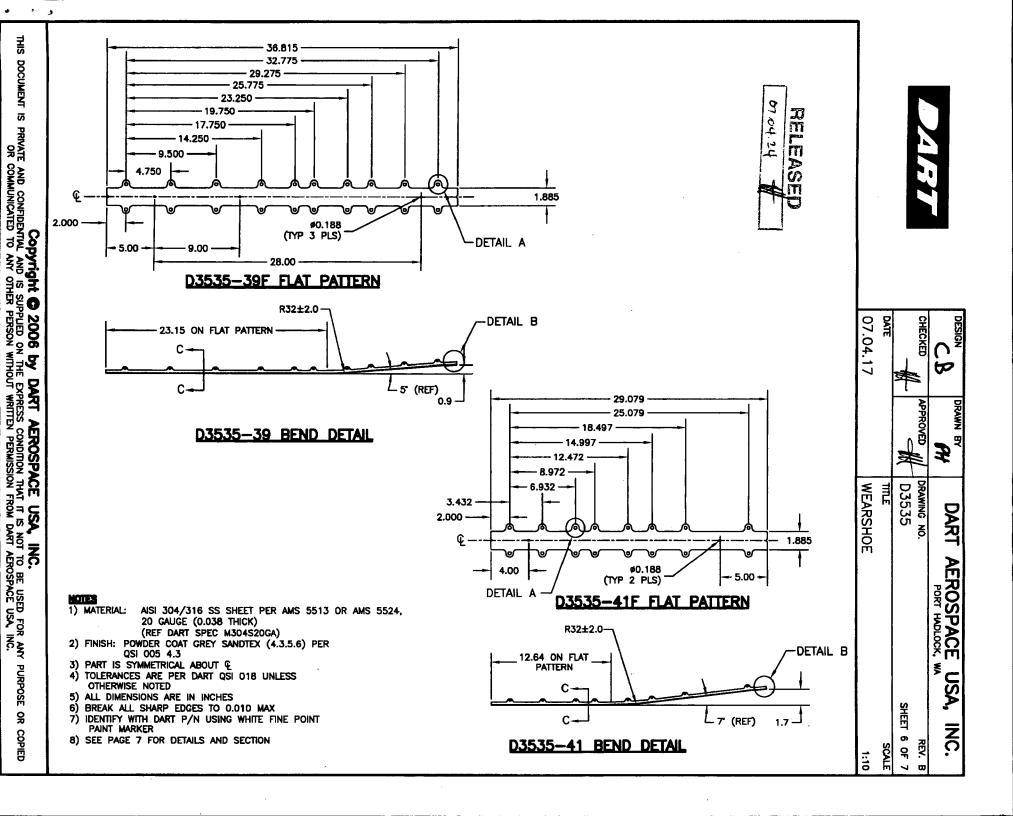
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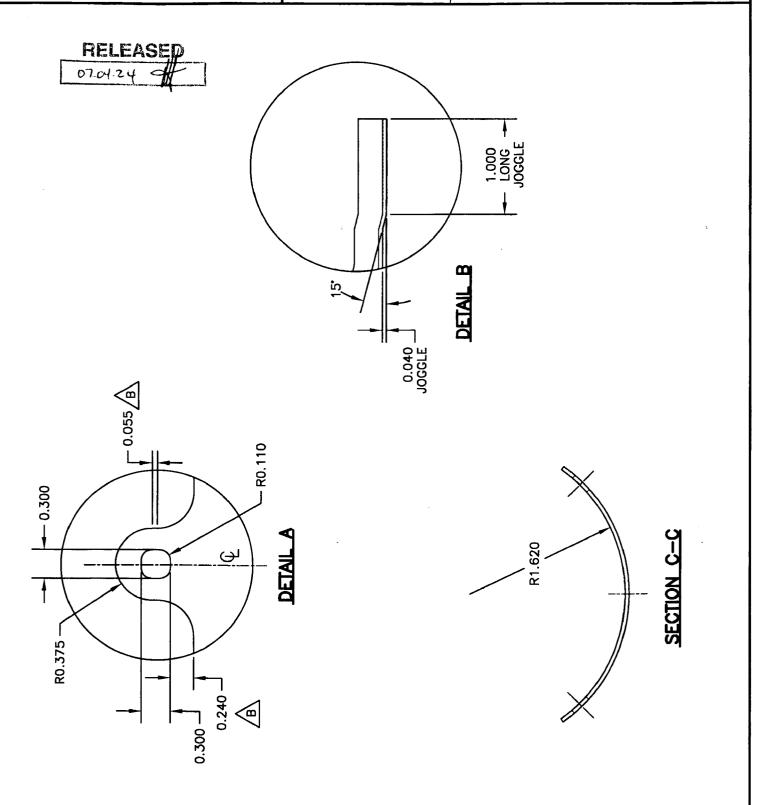
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DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED **/	APPROVED/	DRAWING NO.	REV. B
4		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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